

Work Order ID 53036

October 22, 2009 10:30:39 AM



Page 1

Item ID: D3199-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Bracket

Start Date: 21/10/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: PL

Date: 07-10-22

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3199

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: B

Prog Rev: B

Deburr if required

NAT NOT pulling

B 9-10-30

68

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-10-30

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

2) 8 02/11/02

countes
468



QC

Memo

0.00

Quality Control

130

Small Fab

0.00

SB 09/11/20

68



Small Fab

Memo

0.00

Small Fab

Form as per dwg D3199

140

QC5- Inspect part completeness to step on W/O

0.00

2) 8 02/11/20

countes

468



QC

Memo

0.00

Quality Control

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Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

11112558

0.00

0.00 => 11/09/14/25

(168)

Ø

Memo

START TIME: 7:15 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 7:45 AM

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

=> m-l 09/11/25

(68K)

Memo

170



Packaging

Packaging

Identify as per dwg & Stock Location 236A

0.00

0.00

Memo

11/09/26 (48)

Work Order ID 53036

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Setup Start



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Stop



Item Name: Bracket

Start Date: 21/10/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/26

B/0911-24
68

Picklist Print

Page 1

October 22, 2009 10:30:44 AM

Work Order ID: 53036



Parent Item: D3199-1RevB



Parent Item Name: Bracket

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

124.3128

6.2526



139-10-30

304/316 .040 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

124.3128368

110076

1.37053684

112567

39.7845

112885

83.1578

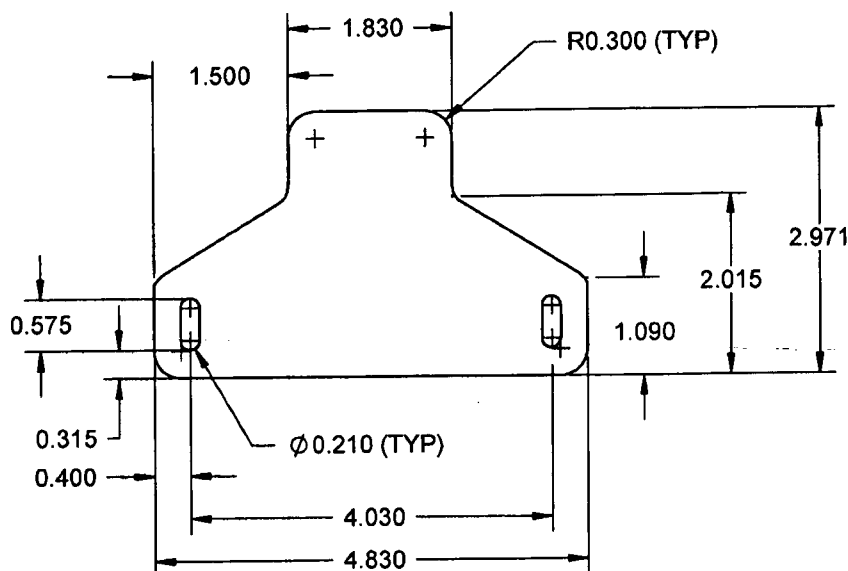
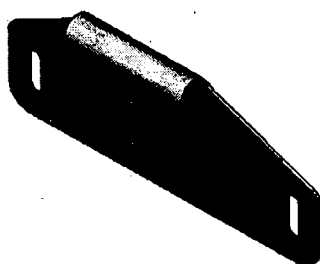
~~11571~~

111571

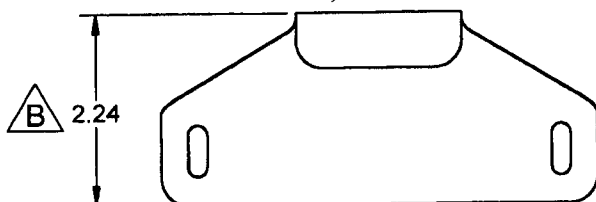
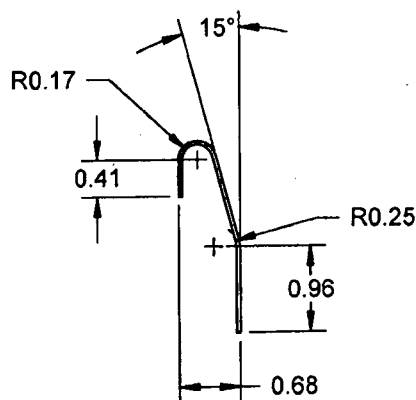
111571

DART

DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3199	REV. B SHEET 1 OF 1
DATE 06.11.01	TITLE BRACKET		SCALE 1:2
REV	DATE	DESCRIPTION	
A	03.08.05	NEW ISSUE	
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	

RELEASED*06.11.20***D3199-1 FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 53086

**D3199-1 BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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